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D3278-3
Job Sheet 207923



Part No: D3278-3

Job Qty: 40 pcs

Part Name: Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/6/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 4/17/20

Description:

Type: Stock

Note: DWG REV C IPP . A 04.04.19 New issue KJ/JLM IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	40 pcs		4/17/20	0.01	0.78	Waterjet - Flow		<i>20/07/27</i>
120	QC 8	40 pcs		4/17/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Small Fab - 2 - B4B	40 pcs		4/17/20	0.00	0.71	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		

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					Small Fab - 3 - B4B	JUL 30 2020	
					Small Fab - 4 - B4B		
					Small Fab - 5 - B4B		
					Small Fab - 6 - B4B		
					Small Fab - 7 - B4B		
					Small Fab - 8 - B4B		
					Small Fab - 9 - B4B		
					Small Fab - Various 1 - B4B		
140 QC 5	40 pcs	4/17/20	0.00 0.00		QC 5 - 10	JUL 30 2020	
					QC 5 - 12		
					QC 5 - 17		
					QC 5 - 18		
					QC 5 - 19		
					QC 5 - 22		
					QC 5 - 24		
					QC 5 - 3		
					QC 5 - 43		
					QC 5 - 49		
					QC 5 - 51		
					QC 5 - 58		
					QC 5 - 68		
					QC 5 - 9		
					QC 5 - 50		
					QC 5 - 30		
					QC 5 - 40		
					QC 5 - 61		
					QC 5 - 81		
150 Packaging 3-1 - Stock - B4B	40 pcs	4/17/20	0.00 0.00		Packaging 3 - 1 - B4B	JUL 31 2020	
					Packaging 3 - 2 - B4B		
					Packaging 3 - 3 - B4B		
					Packaging 3 - 4 - B4B		
					Packaging 3 - 5 - B4B		
					Packaging 3 - 6 - B4B		
					Packaging 3 - 7 - B4B		
					Packaging 3 - 8 - B4B		
					Packaging 3 - 9 - B4B		
					Packaging 3 - 10 - B4B		
					Packaging 3 - 11 - B4B		
					Packaging 3 - 12 - B4B		
					Packaging 3 - 13 - B4B		
					Packaging 3 - 14 - B4B		
					Packaging 3 - 15 - B4B		
					Packaging 3 - 16 - B4B		
					Packaging 3 - 17 - B4B		
					Packaging 3 - 18 - B4B		
					Packaging 3 - 19 - B4B		
					Packaging 3 - 20 - B4B		
					Packaging 3 - 21 - B4B		
					Packaging 3 - 22 - B4B		
					Packaging 3 - 23 - B4B		
					Packaging 3 - 24 - B4B		
					Packaging 3 - 25 - B4B		
					Packaging 3 - 26 - B4B		
					Packaging 3 - 27 - B4B		
					Packaging 3 - 28 - B4B		
					Packaging 3 - 29 - B4B		
					Packaging 3 - 30 - B4B		
					Packaging 3 - 31 - B4B		

				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
160 QC 21 - SA	40 pcs	4/17/20	0.00 0.00	QC 21 - SA - 21	JUL 31 2020
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 120 - (QC8- Inspect parts - second check)
 Descriptions: 130 - (Small Fab)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - Identify as per dwg & Stock Location: _____
 160 - (QC21- Final Inspection - Work Order Release)

DAS
21
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELRRNS0.125	Black Delrin Sheet .125	1.3760 sf (.0344 ea)	100-Waterjet - Flow - 1	5 253964

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	MDELRRNS0.125	1	24	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	1.980inches ± 0.030	2.010 1.950		
2	Spacer	1.980inches ± 0.030	2.010 1.950		
3	Spacer	1.480inches ± 0.005	1.485 1.475		
4	Spacer	0.250inches ± 0.010	0.260 0.240		
5	Spacer	1.480inches ± 0.005	1.485 1.475		
6	Spacer	0.250inches ± 0.010	0.260 0.240		
7	Spacer	0.098inches + 0.005 - 0.000	0.103 0.098		
8	Spacer	0.130inches ± 0.030	0.160 0.100		
9	Spacer	0.125inches ± 0.010	0.135 0.115		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

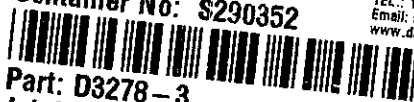
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S290352



Part: D3278-3

Job No: 207923

Serial No/Batch: S290352

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/27/20